

Date: Friday, 22/05/2009 9:59:00 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL, POST RH, LOWER
<b>Job Number</b> : 48133	
<b>Estimate Number</b> : 13946	
<b>P.O. Number</b> :	<b>Part Number</b> : D39474
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3947-4
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : IN0001
<b>First Issue</b> : // <b>Type</b> : R&D THERMOFORMING	<b>Drawing Revision</b> : A PROTOTYPE 09.05.21
<b>Previous Run</b> :	<b>Material</b> : MLEXS093F600607
<b>Written By</b> :	<b>Due Date</b> : 22/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.05.22</u>	
<b>Comment</b> : Est. Rev. A New Issue 09/05/22 DL	

## Additional Product

PROTOTYPE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 3.7275 sf(s)/Unit Total : 3.7275 sf(s)  
 GE PLASTICS LEXAN SHEET

M107574

09.05.22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/22

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/22 (X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3947-4 and folio (FTA 3947-1 Prototype ) using tool DT 9484

Dwg. Rev. AFolio Rev. A

BB 09/05/22 (X1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

ENGINEERING  
APPROVAL

BB 09/05/22 (X1)



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Drawing Name: PANEL, POST RH, LOWER

Job Number: 48133

Part Number: D39474

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

WL 09.05.22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

WL 09.05.22

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

WL 09.05.22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

09.05.22

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

09.05.22  
N/A ENG USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09.05.22

Job Completion



002808  
mf  
09-06-05



DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.6</u> " <u>N/A</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/05/22

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>1.6</u>		<u>1.6</u>	✓			
<u>.5</u>		<u>.5</u>	✓			
<u>.5</u>		<u>.5</u>	✓			
<u>.5</u>		<u>.5</u>	✓			
<u>0.050</u>		<u>0.062</u>	✓			
<u>0.075</u>		<u>0.081</u>	✓			

Measured by: BB

Date: 09.05.22

Audited by: BB

Date: 09/05/22

Prototype Approval: CP

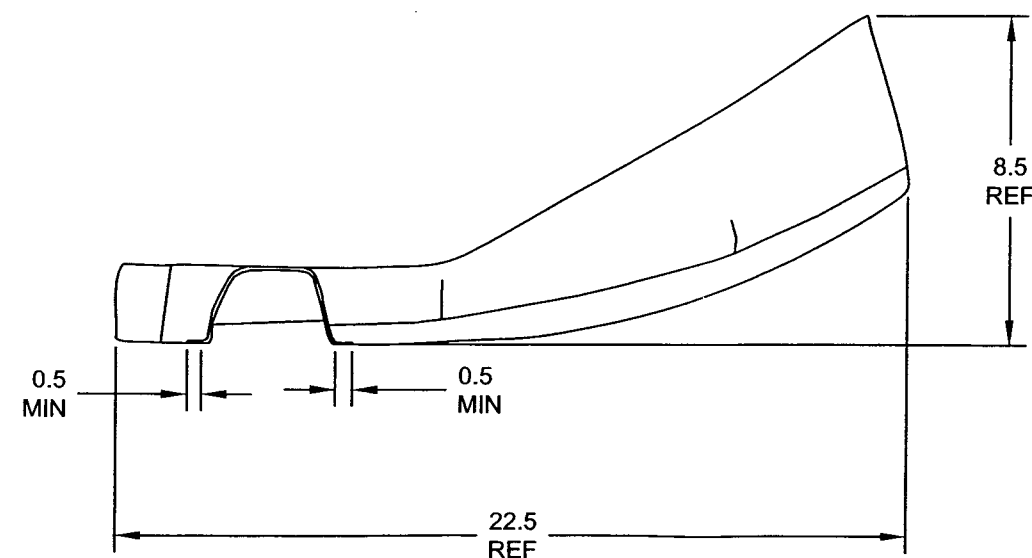
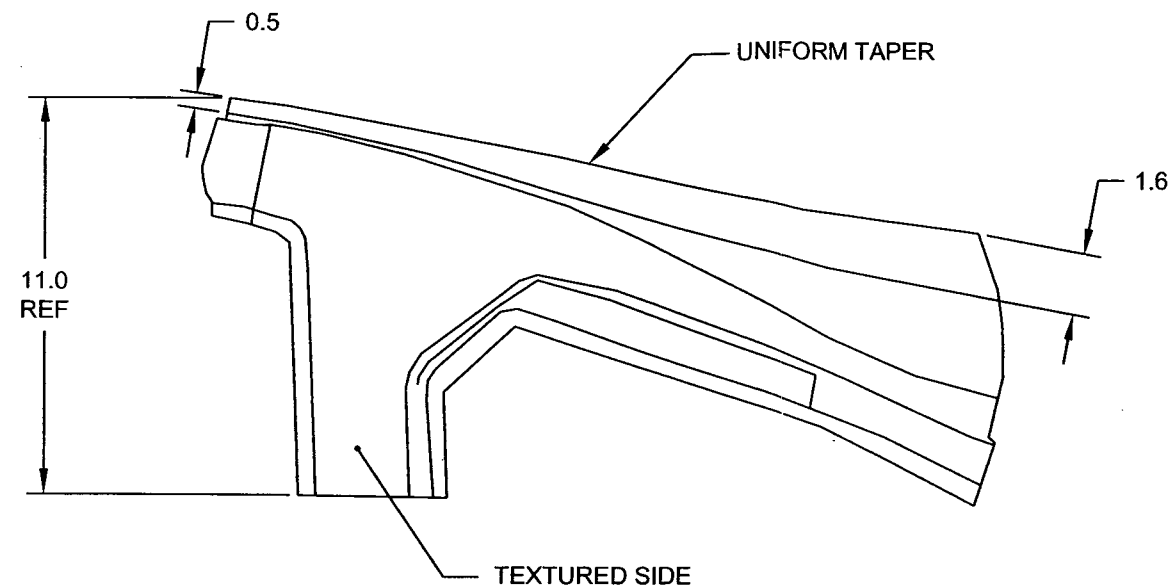
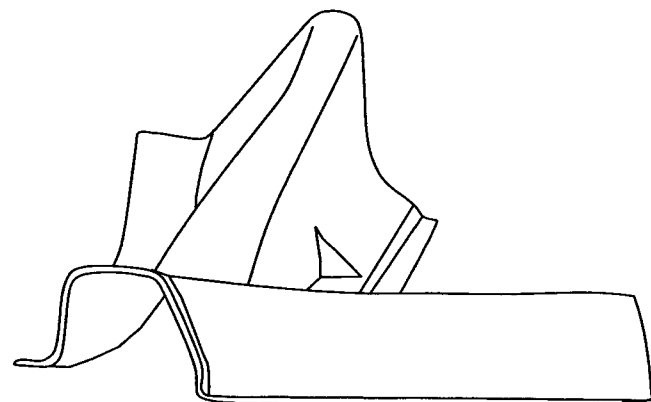
Date: 09/05/22

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

8 7 6 5 4 3 2 1

D

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.05.21



**D3947-4 PANEL, RH**

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.075" ELSEWHERE

DESIGN	09	<b>DART AEROSPACE LTD</b>	
DRAWN	09	HAWKESBURY, ONTARIO, CANADA	
CHECKED	09	DRAWING NO.	REV. A
MFG. APPR.		D3947	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (AS 350/355)	NTS
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